

Ship Oct 15











Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 34800	
Estimate Number : 12517	
P.O. Number : N/A	Part Number : D3514047
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW D3514
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : N/A A 07/09/24
Previous Run : 33292	Material : N/A
Written By : _____	Due Date : 10/12/2007 Qty: 5 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 07-05-28 EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D35143	BOX TOP (TOP MOUNTED)
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) BOX TOP (BOTTOM MOUNTED) Batch: <u>B 34821</u> <i>mf</i>		
2.0	D35147	BOX BOTTOM (TOP MOUNTED)
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) BOX BOTTOM (BOTTOM MOUNTED) Batch: <u>B 34822</u> <i>mf</i>		
3.0	D35149	HOOD
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) HOOD Batch: <u>34823</u> <i>mf</i>		
4.0	D3524041	UPPER AND LOWER PLATE
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) UPPER AND LOWER PLATE Batch: <u>34824</u> <i>mf</i> 07-10-12		
5.0	MS20426AD3 <u>13</u> 07-09-24	RIVET
 		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) RIVET Batch: <u>M1563</u>		

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Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

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Seq. #:

Machine Or Operation:

Description:

6.0

MS20426AD44

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total: 55.0000 Each(s)

Rivet

Batch: M1021

PC

7.0

MS20426AD49

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

RIVET

Batch: M18136

PC

8.0

MS21072L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: M101760

PC 7/9/11

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PRC

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3514

MF

07-10-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MF 07/10/04

11.0

POWDER COATING

POWDER COATING



1X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

MF 07/10/25

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-26

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble trim as per dwg D3514

MF

07-10-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/12	5	split w/o	SK	07/10/12	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/10/2012
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-23	9.0	The 03514-5 had 1 hole enlarged when a rivet was removed. RC: Human error.	<i>[Signature]</i>	Fill hole with weld per Q31004 : grind flush Transfer drill new hole Touch-up area with alcohol. re-rivet : continue ASS'y	<i>[Signature]</i> 07-10-24 mf. 07-10-25	<i>[Signature]</i> 07-10-24	<i>[Signature]</i> 031012	<i>[Signature]</i> 12-10-23

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D35261

RUBBER SEAL



MF

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

RUBBER SEAL

B 34825

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/25

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

07-10-26

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

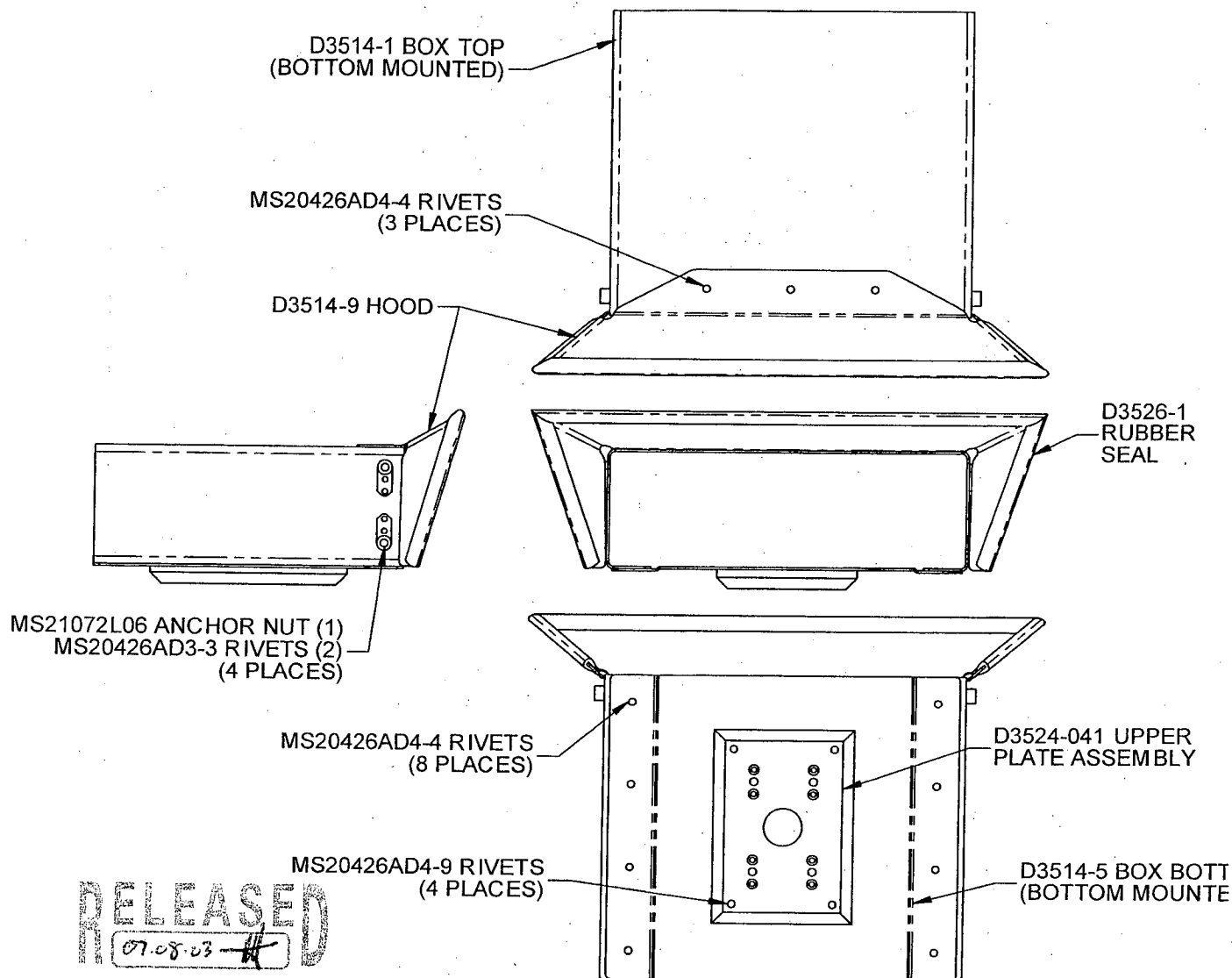
Job Completion



U 07.10.26



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED #	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	



D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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